



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

D4276-1
Job Sheet 177138



Part No: D4276-1

Job Qty: 2 ea

Part Name: Aft Beam



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/7/18

Job Tracking No:

Due Date: 5/11/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 10-11-17 JLM VERIFIED BY:DD IPP rev:B 10.12.02 AS PER DWG
REV.A DD ver:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	2 Ea	5/11/18	5/11/18	0.00	0.00	Start Up Machining-2		<i>mm</i>
100	Bandsaw	2 pcs	5/11/18	5/11/18	0.00	0.03	Bandsaw1		<i>mm</i>
110	CNC Vertical Machining	2 pcs	5/11/18	5/11/18	0.58	3.57	HAAS1-4		<i>mm</i>
120	QC	2 pcs	5/11/18	5/11/18	0.00	0.00	QC2 Machining-2		<i>mm</i>
130	QC	2 pcs	5/11/18	5/11/18	0.00	0.00	QC8 Machining-2		<i>mm</i>
140	HandFinish	2 pcs	5/11/18	5/11/18	0.00	0.24	HandFinish1		<i>mm</i>
145	Powdercoat	2 pcs	5/11/18	5/11/18	0.00	0.18	Powdercoat1		<i>mm</i>
150	QC	2 pcs	5/11/18	5/11/18	0.00	0.00	QC3		<i>mm</i>
180	Packaging	2 pcs	5/11/18	5/11/18	0.00	0.00	Packaging3-2		<i>mm</i>
190	QC21-SA	2 Ea	5/11/18	5/11/18	0.00	0.00	QC21		<i>mm</i>

Part Op 100 - Cut Blank to 36.630"

Descriptions: 110 - 1-Machine per folio FB007

145 - MASK AS PER DWG

M138539 START: 10:30 OUT: 3:00 FINISH: 11:00

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X04.000	6061-T6 Bar 1.00 X 4.00	6.1040 ft (3.052 ea)	90-Start up Operation	

2x 3059687

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X04.000	6	29	0

Part Specifications

Specifications could not be found.



Container No: S069536



Part: D4276-1

Job No: 177138

Serial No/Batch: S069536

Revision:

Inspector:

1210 PAVILION DRIVE
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CANADA
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Date: 05/08/18

2A0
11
88-4

DART AEROSPACE LTD		Work Order: 127130
Description: Aft Beam		Part Number: D4276-1
Inspection Dwg: D4276	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030	.750	✓		Vernier	
20.500	+/-0.010	20.501	✓		Tape	
Ø0.381	+0.000/-0.001	.380	✓		Pin gage	
14.380	+/-0.010	14.375	✓		high gage	
R0.75	+/-0.030	R.750	✓		Gobern	
3.50	+/-0.030	3.500	✓		Vernier	
16.38	+/-0.030	16.380	✓		Tape	
5.00	+/-0.030	4.999	✓		Vernier	
0.75	+/-0.030	.750	✓		high gage	
2.75	+/-0.030	2.750	✓		Vernier	
3.00	+/-0.030	3.00	✓		Vernier	
1.250	+/-0.010	1.249	✓		Vernier	
4.50	+/-0.030	4.509	✓		Vernier	
0.734	+/-0.010	.735	✓		Vernier	
0.108	+/-0.010	.108	✓		high gage	
36.38	+/-0.030	36.375	✓		Tape	
0.95	+/-0.030	.938	✓		Vernier	
0.60	+/-0.030	.599	✓		Vernier	
2.70	+/-0.030	2.698	✓		Vernier	
1.10	+/-0.030	1.098	✓		Vernier	
1.25	+/-0.030	1.249	✓		Vernier	
0.75	+/-0.030	.748	✓		Vernier	
3.000	+/-0.010	2.999	✓		Vernier	
1.500	+/-0.010	1.500	✓		Vernier	
Ø0.191	+0.005/-0.001	.195	✓		Pin gage	
2.300	+/-0.010	2.299	✓		Vernier	
3.50	+/-0.030	3.499	✓		Vernier	
R0.60	+/-0.030	R.600	✓		Gobern	
1.70	+/-0.030	1.702	✓		Vernier	
0.65	+/-0.030	.648	✓		Vernier	

Measured by: [Signature]	Audited by:	Preliminary Approval:
Date: 2018/05/08	Date:	Date:

Rev	Date	Change	Revised by	Approved
A	11.08.22	New Issue	KJ [Signature]	[Signature]